



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3076-1
Job Sheet 168589



Part No: D3076-1

Job Qty: 4 ea

Part Name: R22 Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/17/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A1 IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM IPP Rev:D 08-11-10 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/7/17	0.00	0.00	Start Up Container		<i>SP</i>
110	Waterjet	4 pcs		12/7/17	0.00	0.77	Waterjet1		<i>SP</i>
120	CNC Vertical Machining	4 pcs		12/8/17	0.00	3.29	HAAS 1		
130	QC	4 pcs		12/8/17	0.00	0.00	QC2		
140	QC	4 pcs		12/8/17	0.00	0.00	QC8		
150	Packaging	4 pcs		12/8/17	0.00	0.00	Packaging3		<i>FK 17-12-12</i>
160	QC21-SA	4 Ea		12/8/17	0.00	0.00	QC21		<i>SP</i>

Part Op 110 - Cut Blank as per file D3076-1_BLANK

Descriptions: 120 - Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA186 and Dwg D3076 3-Identify as D3076-1 4-Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	4	1,190	0	0

Part Specifications

Specifications could not be found.

Plex 11/17/17 1:16 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____

DART
AEROSPACE
S012432

**R22 Bearpaw****Dart Aerospace Ltd.**
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 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

PART NO: D3076 – 1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/22/17**Job No: 168589**

Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER :

DART AEROSPACE LTD		Work Order:	168589
Description: R22 Bearpaw		Part Number:	D3076-1
Inspection Dwg: D3076 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.065 x 45°	✓		Ver	ED-6
B	0.63	+/-0.030	0.633	✓		Ver	ED-6
C	0.250	+/-0.010	0.247	✓		Mic	65011351
D	0.950	+0.030/-0.010	0.951	✓		Ver	ED-6
E	5.50	+/-0.030	5.50	✓		Ver	ED-6
F	0.25 x 45°	+/-0.030	0.25 x 45°	✓		TAPE	
G	0.375	+/-0.010	0.384	✓		Mic	65011351
H	0.475	+/-0.010	0.483	✓		Ver	ED-6
I	5.83	+/-0.030	5.833	✓		Ver	ED-6
J	3.80	+/-0.030	3.802	✓		Ver	ED-6
K	3.046	+/-0.010	3.049	✓		Ver	ED-6
L	3.638	+/-0.010	3.643	✓		Ver	ED-6
M	0.260	+0.005/-0.000	0.260	✓		G.P.	
N	0.93	+/-0.030	0.930	✓		Ver	ED-6
O	0.30	+0.030/-0.000	0.305	✓		Ver	ED-6
P	7.000	+/-0.010	7.006	✓		Ver	SBL-01
Q	10.14	+/-0.030	10.14	✓		TAPE	

Measured by: SC/jmk	Audited by: FK-	Prototype Approval:	N/A
Date: 17/12/11	Date: 17-12-12	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D022-661-011	KJ/RF	